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647.4313

Job Sheet 206670



Part No: 647.4313

Job Qty: 4 pcs

Part Name: RH Upper Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/20

Job Tracking No:

Due Date: 3/20/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.06 CHG MATERIAL
TO S.S. DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs			0.17	0.14	Waterjet - Flow		on 20/04/01
120	QC 2	4 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/04/01
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
QC 2 - 62									
QC 2 - 63									
QC 2 - 8									
QC 2 - 66									
QC 2 - 64									

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130 QC 8	4 pcs	0.00 0.00	QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
140 Small Fab - 2 - B4B	4 pcs	0.00 1.42	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
150 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	

ADD 01 2020
9-88

MV

2

160 Large Fab - Welded Assy-2-B4B	4 pcs	0.00 1.60	QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	NV April 13/20
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 QC 9	4 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	
			QC 9 - 43	
			QC 9 - 50	62
			QC 9 - 9	
180 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	62
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	DAS
190 Spray Paint - 2 - B4B	4 pcs	0.00 0.27	Spray Paint - 1 - B4B	41 APR 14 2020
			Spray Paint - 2 - B4B	489
			Spray Paint - 3 - B4B	
			Spray Paint - 4 - B4B	
200 QC 14	4 pcs	0.00 0.00	QC 14 - 15	
			QC 14 - 2	
			QC 14 - 34	
			QC 14 - 41	
			QC 14 - 51	
			QC 14 - 58	
			QC 14 - 59	
			QC 14 - 9	
			QC 14 - 68	
			QC 14 - 40	APR 14 2020
			QC 14 - 19	
			QC 14 - 43	
			QC 14 - 24	
			QC 14 - 61	

210 Packaging 3-1 - Stock - B4B 8 pcs	0.00 0.00	QC 14 - 81	
		QC 14 - 82	
		Packaging 3 - 1 - B4B	
		Packaging 3 - 2 - B4B	DAS
		Packaging 3 - 3 - B4B ✓	CCK075 80
		Packaging 3 - 4 - B4B	9-89
		Packaging 3 - 5 - B4B	
		Packaging 3 - 6 - B4B	APR 16 2020
		Packaging 3 - 7 - B4B	
		Packaging 3 - 8 - B4B	
		Packaging 3 - 9 - B4B	
		Packaging 3 - 10 - B4B	
		Packaging 3 - 11 - B4B	
		Packaging 3 - 12 - B4B	
		Packaging 3 - 13 - B4B	
		Packaging 3 - 14 - B4B	
		Packaging 3 - 15 - B4B	
		Packaging 3 - 16 - B4B	
		Packaging 3 - 17 - B4B	
		Packaging 3 - 18 - B4B	
		Packaging 3 - 19 - B4B	
		Packaging 3 - 20 - B4B	
		Packaging 3 - 21 - B4B	
		Packaging 3 - 22 - B4B	
		Packaging 3 - 23 - B4B	
		Packaging 3 - 24 - B4B	
		Packaging 3 - 25 - B4B	
		Packaging 3 - 26 - B4B	
		Packaging 3 - 27 - B4B	
		Packaging 3 - 28 - B4B	
		Packaging 3 - 29 - B4B	
		Packaging 3 - 30 - B4B	
		Packaging 3 - 31 - B4B	
		Packaging 3 - 32 - B4B	
		Packaging 3 - 33 - B4B	
		Packaging 3 - 34 - B4B	
		Packaging 3 - 35 - B4B	
		Packaging 3 - 36 - B4B	
		Packaging 3 - 37 - B4B	
220 QC 21 - SA 8 pcs	0.00 0.00	QC 21 - SA - 21 ✓	CCK075
		QC 21 - SA - 70	DAS
		QC 21 - SA - 53	9-89

Part Op 110 - 1-Cut 647.4312 plate 3.928X1.985 as per Dwg
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab) 1- Fabricate tube as per dwg by cutting (22.00") one end 27.7 degree and other end punch, bend and drill hole as per dwg
 150 - QC5- Inspect part completeness to step on W/O)
 160 - (Weld per dwg A/R S.S. rod Batch M19023) Weld tube to plate as per dwg.
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Spray Paint / NDT Room) Prime as per dwg (see note 4) 5265778
 200 - (QC14- Inspect Spray Paint)
 210 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.2160 sf (.054 ea)	110-Waterjet - Flow - 1	<u>5263583</u>
M304TR0.500W.049	304 Round Tube .500 X .049W	7.3200 ft (1.83 ea)	140-Small Fab - 2 - B4B	<u>5244045</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	0	142	0
140-Small Fab - 2 - B4B	M304TR0.500W.049	7	149	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	RH Upper Strut	1.985inches $\pm$ 0.005	1.990 1.980	1.987	
2	RH Upper Strut	3.928inches $\pm$ 0.005	3.933 3.923	3.927	
3	RH Upper Strut	0.063inches $\pm$ 0.005	0.068 0.058	.058	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

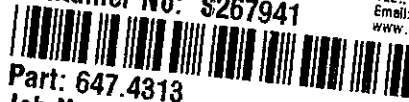
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

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AEROSPACE

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Container No: S267941



Part: 647.4313

Job No: 206670

Serial No/Batch: S267941

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/01/20